

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014205**Date Inspected:** 11-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sub-Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

BAY 1:

Flux Cored Arc Welding (FCAW) of 20TR1-024; Weld(s) 001 and 003. Welder(s) are identified as 219188. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-025; Weld(s) 005 and 007. Welder(s) are identified as 250672. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

BAY 2:

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair #B-CWR1096 (Buttering for length) of 10TR1-008. Welder(s) are identified as 045203. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to

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conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair #B-CWR1096 (Buttering for length) of 11TR2-018. Welder(s) are identified as 045203. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

BAY 5:

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10388 (for UT reject) of 10TR1-015; Weld(s) 014. Welder(s) are identified as 222387 and 204342. ZPMC Quality Control (QC) is identified as Shen Jian Guo. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10361 (for UT reject) of 11TR3-023; Weld(s) 014. Welder(s) are identified as 215689 and 204342. ZPMC Quality Control (QC) is identified as Shen Jian Guo. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

BAY 6:

Flux Cored Arc Welding (FCAW) of USPL1-366; Weld(s) 001 and 002. Welder(s) are identified as 053609. ZPMC Quality Control (QC) is identified as Huang Min. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of USPL1-371; Weld(s) 001 and 002. Welder(s) are identified as 217185. ZPMC Quality Control (QC) is identified as Liu Chuan Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of USPL1-365; Weld(s) 001 and 002. Welder(s) are identified as 053609. ZPMC Quality Control (QC) is identified as Liu Chuan Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of USPL1-329; Weld(s) 001 and 002. Welder(s) are identified as 217185. ZPMC Quality Control (QC) is identified as Liu Chuan Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

BAY 7:

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10310 (for UT reject) of 10TR3-006; Weld(s) 014. Welder(s) are identified as 053742. ZPMC Quality Control (QC) is identified as Xia Yong Zheng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
